

44

Date: Friday, 10/5/2007 11:03:50 AM
 User: Kim Johnston

Process Sheet

Customer : CU-DAR001 Dart Helicopters Services Drawing Name : N1 GEARBOX ACCESS PANEL KIT
 Job Number : 35052
 Estimate Number : 12505
 P.O. Number :
 This Issue : 10/5/2007 S.O. No. :
 Prsht Rev. : NC Part Number : D412705017
 First Issue : / / Type : SMALL / MED FAB Drawing Number : D3255 REV B
 Previous Run : 33598 Drawing Revision : B
 Material :
 Due Date : 10/30/2007 Qty: 2 Um: Each
 Written By :
 Checked & Approved By : 07.10.05
 Comment : Est Rev: C Removed Manufacturing 06-08-02 JLM

Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :
1.0	DC	DOCUMENT CONTROL



Comment: Photocopy bluefile & type labels per PPPD412-705-017 CHG001

08/01/08

2.0	PACKAGING 1	PACKAGING RESOURCE #1
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Comment: PACKAGING RESOURCE #1
 Pick Packing Kit

3.0	D3255041	Access Panel Assembly
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Comment: Qty.: 1.0000 Each(s)/Unit Total : 2.0000 Each(s)

Access Panel Assembly

Batch: B28124 1X B 33603

10/08/05
Pu

4.0	D3255042	Access Panel Assembly
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Comment: Qty.: 1.0000 Each(s)/Unit Total : 2.0000 Each(s)

Access Panel Assembly

B28125 33604 8/1/08 (2) 50

5.0	AN3C3A	Bolt
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Comment: Qty.: 30.0000 Each(s)/Unit Total : 60.0000 Each(s)

Bolt

Batch: M106277

Pu

6.0	MS932109	Washer
-----	----------	--------



Comment: Qty.: 30.0000 Each(s)/Unit Total : 60.0000 Each(s)

Washer

M106277 17X M10688348X 8/01/06 (2)

Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes ☐ No ☒ DQA: D Date: 08/01/31
 QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Date: Friday, 10/5/2007 11:03:50 AM
User: Kim Johnston

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: N1 GEARBOX ACCESS PANEL KIT

Job Number: 35052

Part Number: D412705017

Job Number:



Seq. #:

Machine Or Operation:

Description :

7.0

MS20427M33

Rivet



Comment: Qty.: 48.0000 Each(s)/Unit Total : 96.0000 Each(s)

Rivet

Batch: M106277 16x M106303 80x

8.0

MS21060L3K

Nut Plate



Comment: Qty.: 24.0000 Each(s)/Unit Total : 48.0000 Each(s)

Nut Plate

Batch: M10678 40x M106256 8x

9.0

QC4

INSPECT 100% KITS FOR COMPLETENESS



Comment: INSPECT 100% KITS FOR COMPLETENESS

10.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and pack for shipping as per PPP D412-705-017

Location: A

PPP Rev: A

11.0

QC21

FINAL INSPECTION/W/O RELEASE



Comment: FINAL INSPECTION/W/O RELEASE

Job Completion



u 08101.31

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

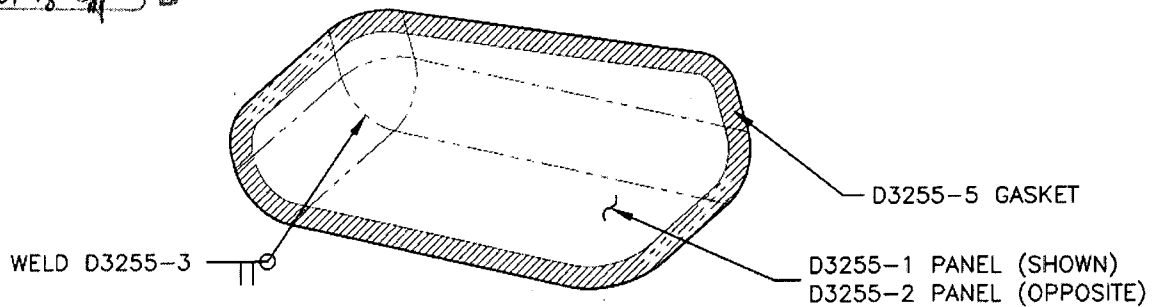
NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

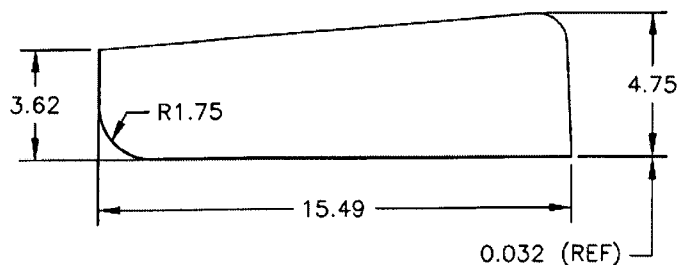
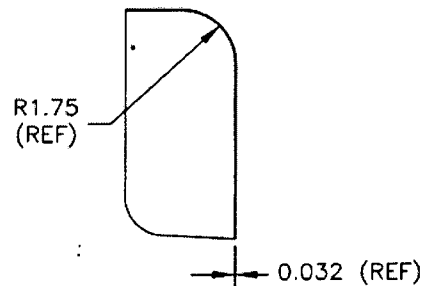
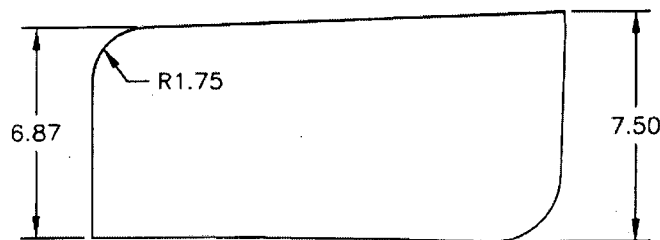


DESIGN RT	DRAWN BY RT	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED ip	APPROVED [Signature]	DRAWING NO. D3255	REV. B SHEET 1 OF 4
DATE 04.12.06		TITLE ACCESS PANEL ASSEMBLY	SCALE 1:6
A	04.01.27	NEW ISSUE	
B	04.12.06	D3255-3 REDESIGN; ADDED $\phi 0.098$	

RELEASED
05-01-18 #



D3255-041 ACCESS PANEL (SHOWN)
D3255-042 ACCESS PANEL (OPPOSITE)



D3255-1 BEND DETAIL
D3255-2 OPPOSITE

D3255-041/-042 NOTES:

- 1) WELD PER DART QSI 004
- 2) FINISH: POWDER COAT GREY SANDTEX (4.3.5.6) PER QSI 005 4.3
- 3) INSTALL D3255-5 GASKET USING DOW CORNING P/N 736 ADHESIVE IN ACCORDANCE WITH MANUFACTURE'S INSTRUCTIONS
- 4) IDENTIFY WITH P/N & B/N USING FINE POINT PERMANENT MARKER

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WORK ORDER
NO. 35052

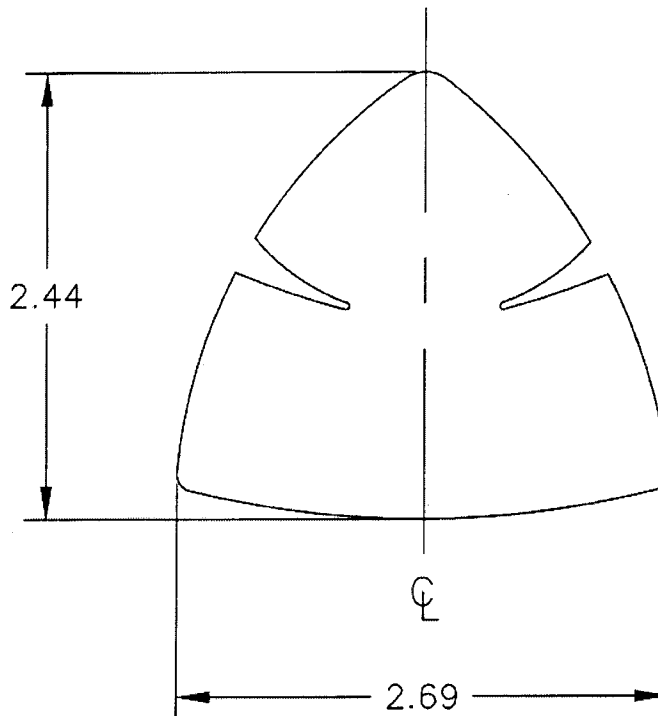
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CHECKED 9P	APPROVED [Signature]	DRAWING NO. D3255	REV. B SHEET 2 OF 4
DATE 04.12.06	TITLE TITLE		SCALE 1:1

RELEASED
05-01-18 #



D3255-3 CAP
FORM TO FIT D3155-1/-2

D3255-3 NOTES:

- 1) MATERIAL: AISI 304/316 SS 0.032 THICK (REF. M304S22GA)
- 2) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 3) ALL DIMENSIONS ARE IN INCHES
- 5) BREAK ALL SHARP EDGES 0.005 TO 0.010
- 6) MAKE PER DRAWING "D3255-B2.DWG"

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WITHOUT NOTICE
WORK ORDER
NO. 35052

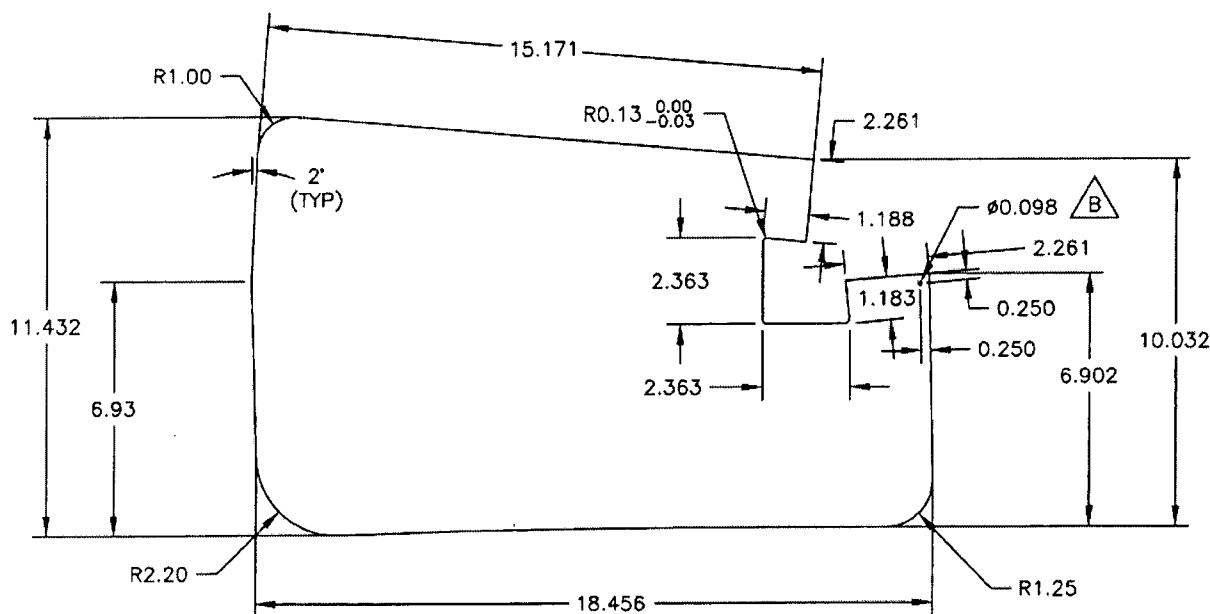
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CHECKED UP	APPROVED [Signature]	DRAWING NO. D3255	REV. B SHEET 3 OF 4
DATE 04.12.06		TITLE ACCESS PANEL ASSEMBLY	SCALE 1:5

RELEASED
05-01-18



D3255-1/-2 FLAT PATTERN

D3255-1/-2 NOTES:

- 1) MATERIAL: AISI 304/316 SS 0.032 THICK (REF. M304S22GA)
- 2) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 3) ALL DIMENSIONS ARE IN INCHES
- 4) BREAK ALL SHARP EDGES 0.005 TO 0.010

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NO. 35052

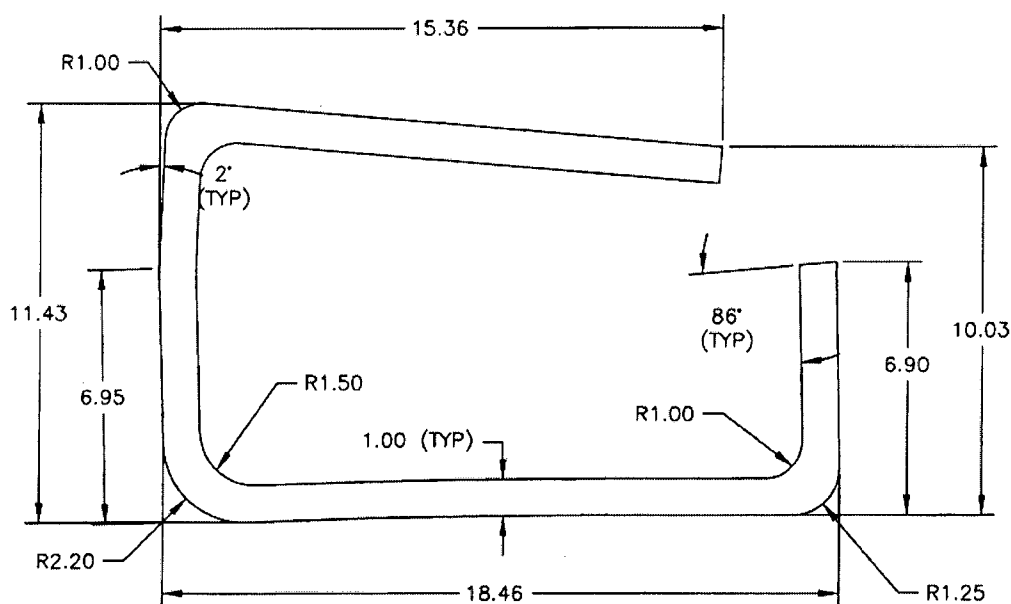
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DESIGN #	DRAWN BY #	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED 4P	APPROVED #	DRAWING NO. D3255	REV. B SHEET 4 OF 4
DATE 04.12.06		TITLE ACCESS PANEL ASSEMBLY	SCALE 1:5

RELEASED
05-01-18 #



D3255-5 GASKET

D3255-5 NOTES:

- 1) MATERIAL: SILICONE COATED FIBERGLASS CLOTH PER AMS 3320F
P/N SIL/F 36x36x1/16
POSSIBLE SUPPLIER: AVIALL
- 2) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 3) ALL DIMENSIONS ARE IN INCHES

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User: Kim Johnston

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Customer : CU-DAR001 Dart Helicopters Services
Job Number : 35052
Estimate Number : 12505
P.O. Number :
This Issue : 10/5/2007 S.O. No. :
Prsht Rev. : NC
First Issue : / / Type : SMALL /MED FAB
Previous Run : 33598
Written By :
Checked & Approved By :
Comment : Est Rev:C Removed Manufacturing 06-08-02 JLM

Drawing Name : N1 GEARBOX ACCESS PANEL KIT
Part Number : D412705017
Drawing Number : D3255 REV B
Project Number : N/A
Drawing Revision : B
Material :
Due Date : 10/30/2007 Qty: 2 Um: Each

Additional Product

Job Number:



Seq. #: Machine Or Operation: Description :

1.0 DC DOCUMENT CONTROL



Comment: Photocopy bluefile & type labels per PPPD412-705-017 CHG001

07.10.09

2.0 PACKAGING 1 PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1
Pick Packing Kit

3.0 D3255041 Access Panel Assembly



Comment: Qty.: 1.0000 Each(s)/Unit Total : 2.0000 Each(s)
Access Panel Assembly
Batch: _____

4.0 D3255042 Access Panel Assembly



Comment: Qty.: 1.0000 Each(s)/Unit Total : 2.0000 Each(s)
Access Panel Assembly

REFERENCE ONLY

5.0 AN3C3A Bolt



Comment: Qty.: 30.0000 Each(s)/Unit Total : 60.0000 Each(s)
Bolt
Batch: _____

6.0 MS932109 Washer



Comment: Qty.: 30.0000 Each(s)/Unit Total : 60.0000 Each(s)
Washer